

**\*76171\***

Monday, November 07, 2011 12:59:25 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*12\***

**\*12\***

**Customer:**

Run Start \*NR1\*

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop  \*NR2\*

<b>Draw Nbr</b>	<b>Revision Nbr</b>
D3293	Rev A

0.00

**\*100\***

## FLOW WATER JET

0.00

Waterjet

## Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3293    Dwg Rev: A    Prog Rev: A    2-

2024.08.01

Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

## Memo

0.00

QC

## Quality Control

120

QC8- Inspect parts - second check

0.00

**\*120\***

## Memo

0.00

QC

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 76171****\*76171\***

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Monday, November 07, 2011 12:59:25 PM

Item ID: D3293-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Doubler  
Start Date: 11/7/2011 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 11/16/2011 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Small Fab	Small Fab	0.00							
	Memo	0.00							
	1- Deburr								
140 <b>*140*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
150 <b>*150*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
	Memo	0.00							

u/45

M/A 11-12-23 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 76171

**\*76171\***

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Monday, November 07, 2011 12:59:25 PM

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Revision ID: Stop **\*NS2\***  
Item Name: Doubler  
Start Date: 11/7/2011 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 11/16/2011 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*160*</b>									
Powdercoat		0.00							
Powder Coating									
	Memo								
	START TIME: 10:30								
	FINISH TIME: 11:00								
170	QC3- Inspect Part Finish	0.00							
<b>*170*</b>									
QC		0.00							
Quality Control	Memo								
180	Identify as per dwg & Stock Location 211	0.00							
<b>*180*</b>									
Packaging		0.00							
Packaging	Memo								

12X 11/12/23

12 11-12 30.

11/12/29 12/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**Work Order ID 76171****\*76171\***

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Monday, November 07, 2011 12:59:25 PM

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Item Name: Doubler  
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Required Date: 11/16/2011 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

CR 12/01/02

11-12-29  
G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Monday, November 07, 2011 12:59:31 PM

Work Order ID: 76171

\*76171\*

Parent Item: D3293-1

\*D3293-1\*

Parent Item Name: Doubler

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: A04.08.24New issueKJ/JLM  
IPP Rev:B Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	204.3000	1.8264	23.07032			
									**			11-12-22	

\*M2024T3S 080\*

2024-T3 .080 sheet

Location	Loc Qty	Loc Code
MAT022	204.3	
105411	6	
109424	4	
110347	0.5	
112331	3	
113796	7	
114025	15.7	
116604	5.8	
117392	40.1	
118180	49.7	
119117	72.5	

119117

(12)

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

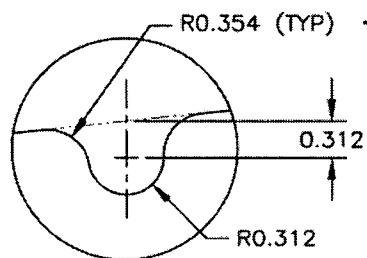
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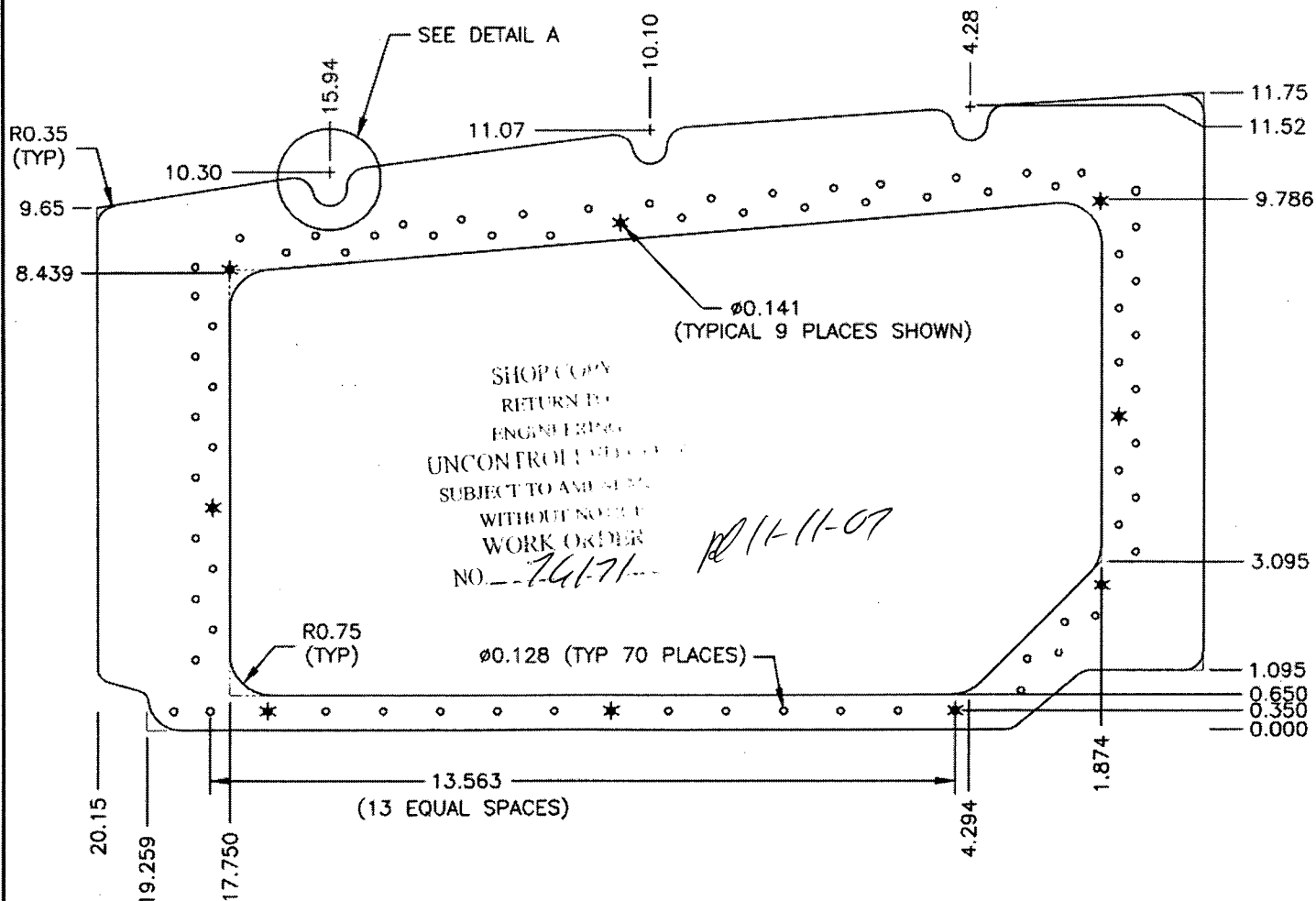
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CHECKED	APPROVED	DRAWING NO.		REV. A	
		D3293		SHEET 1 OF 1	
DATE		TITLE		SCALE	
04.06.28		DOUBLER		1:3	
A		04.06.28		NEW ISSUE	

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



**DETAIL A**  
SCALE 2:3

04.07.72 - ~~11~~



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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